

Date: Friday, 10/5/2007 10:59:52 AM
User: Kim Johnston

Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 L HIGH GEAR SKIDTUBE
Job Number : 35039A	
Estimate Number : 10539	
P.O. Number :	Part Number : D206642341
This Issue : 10/5/2007 S.O. No. :	Drawing Number : D2650 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : E
Previous Run : 30415A	Material :
Written By :	Due Date : 10/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>7.10.05</u>	
Comment : Est Rev. H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JL M	

Additional Product

Job Number:



SCVAP

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG002

NIA

2.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B34692

DP 7-10-10

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2647

Fwd Cap

B29328

BE 7-10-10

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod m 105138

BE 7-10-10

4-Grind weld flush to cap on top surface only.

BE 7-10-10

DP 7-10-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end to length as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A, & B). Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

AWM/DD
- 07-10-17

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AWM
07-10-17



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26545

206 L Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

B-29779

AWM
07-10-17

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 07-10-17 Time: 3:25

Finish Date: 07-10-17 Time: 8:30 AM

A/R Sikaflex-291

Sikaflex expiry date:

17105458
08-01-01

AWM/DD
07-10-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description:

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Go A10/18 (81)

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

19 D2649

Crossbolt spacer

234612 BE 07-10-18

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



P10

Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod
A/R Aluminum Rod M 105138 BE 07-10-18

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

SL 7-10-23

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

H 7-10-23

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-341 PAR #: NA Fault Category: Prod/Landing ^{GEN} NCR: Yes No DQA: D Date: 07/11/05
 QA: N/C Closed: H Date: 07.11.06

NCR: <u>35039A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/10/02	10.0	4 x-bolt spacers including 2 spacers are off center by 0.030" → 0.040" R.C. x-bolt spacers holes (possibly) not centered on the edge	<u>05/10/02</u>	- Remove and replace 4x D2946 B-B-346/2 And weld center on the ridge per Doug and AS2004	<u>7-10-22</u> <u>AE</u> <u>7-10-23</u>	<u>07-11-01</u>	<u>AS10/02</u>	<u>07-11-22</u>
07-10-02	10.0	X-bolt spacers were bored out crooked due to the pilot on the tool being loose.	<u>07/10/02</u>	- Grind Flush - replace pilot - scrap, destroy tube. - See Attached e-mail.	<u>AWM</u> <u>07-11-03</u>		<u>07/11/02</u>	<u>07-11-01</u>

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Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 M7885/3-4-3 Rivets

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

21.0

D265611

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

SCVMP
NFG

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Job Number: 35039A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe _____

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-35

Wearshoe _____

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad _____

25.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 ALS4-1032-130

Inserts _____

or (see QSI 017)

26.0

AN960JD10L

Washer



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 AN960JD10L

Washer _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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QA: N/C Closed: _____ Date: _____

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Job Number: 35039A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS27039108

Screw



Comment: Qty.: 54.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 MS27039-1-08

Screw _____

28.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs _____

29.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings _____

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer _____

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw _____

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 35039A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D2646

Aft Cap _____

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer _____

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw _____

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 _____

Sikaflex expiry date: _____

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.
Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 _____

Sikaflex expiry date: _____

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 35039A

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

37.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>OP</i>	DRAWN BY <i>OP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
16 04 17 *H*

Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER.
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET


NOTES


- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
35037A

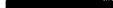

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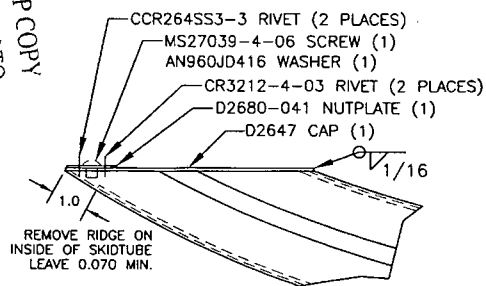
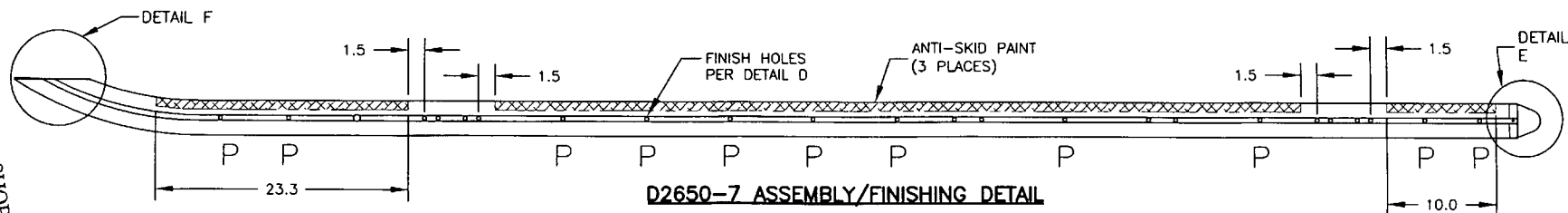
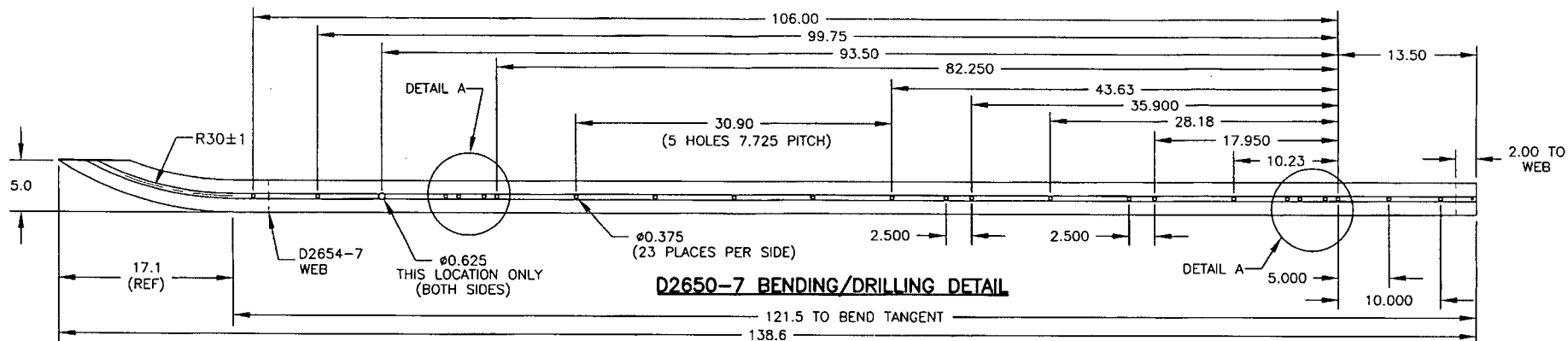
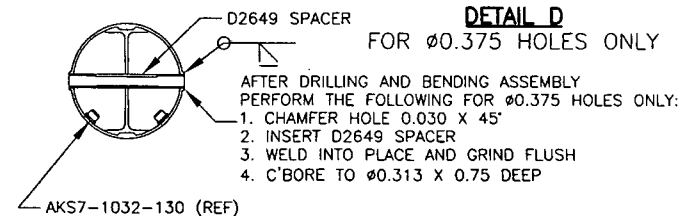
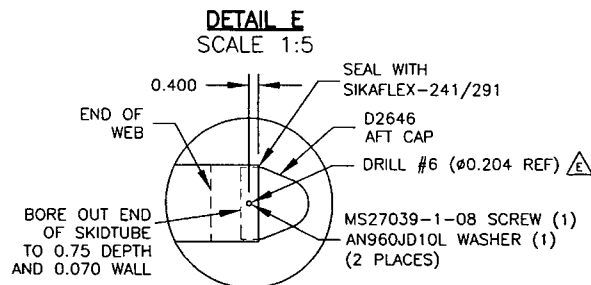
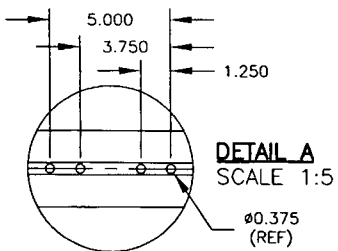
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DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	 DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	<i>PH</i>	APPROVED	<i>H</i>	
DATE		TITLE		REV. E
06.03.30		SKIDTUBE		SHEET 2 OF 5
				SCALE 1:10

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	CHECKED	APPROVED		DRAWING NO.	REV. E
	DATE	TITLE			SHEET 3 OF 5
					SCALE
	06.03.30	SKIDTUBE		1:10	



DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. E
PH		D2650	SHEET 4 OF 5
DATE		TITLE	SCALE
06.03.30		SKIDTUBE	1:10



- DETAIL F (NOT TO SCALE)**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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DESIGN	UP	DRAWN BY	UP	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	PH	APPROVED	PH	DRAWING NO. D2650
DATE	06.03.30	TITLE	SKIOTUBE	REV. E SHEET 5 OF 5 SCALE 1:10

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D2680-041

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, November 01, 2007 11:27 AM
To: 'Chris Provencal'
Cc: 'L Lacelle'; 'Mike Petsche'; 'Jason Murdoch'
Subject: RE: NCR D206-642-341 B35039

Agree ... scrap the fucker ... pardon me ... scrap the skidtube, please.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, November 01, 2007 9:05 AM
To: 'Jason Murdoch'
Cc: 'L Lacelle'; 'David Shepherd'; 'Mike Petsche'
Subject: RE: NCR D206-642-341 B35039

Because some of the saddle and ground handling holes are affected, I think we should scrap the skidtube. I will see Bill about scrapping the tube later today, unless David adds an over-riding disposition.

-Chris

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: November 1, 2007 10:17 AM
To: 'Mike Petsche'
Cc: 'Chris Provencal'; 'L Lacelle'; 'David Shepherd'
Subject: FW: NCR D206-642-341 B35039

Can you take a look at this, or is David?

jmurdoch@dartaero.com
Q.C. COORDINATOR

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Tuesday, October 23, 2007 2:33 PM
To: 'Mike Petsche'
Cc: 'Chris Provencal'; 'L Lacelle'
Subject: NCR D206-642-341 B35039

I tried to take some pics to show you, but the ex engineering camera is pretty s__ty (feel free to fill the blanks). There were a few, (9) crossbolt spacers that had to be changed because they were off center a lot, and noticed after welding. Now a new problem came to, where the counter bore tip was loose, and caused the holes to become off center AGAIN. I don't feel comfortable doing this, in fear of cracks, but can the cross bolt spacers be replaced and re-welded 1 more time? This would be the 3rd time being welded. The c'bore tip has since been replaced.

jmurdoch@dartaero.com
Q.C. COORDINATOR

11/1/2007